

Date: Thursday, 22/01/2009 2:33:14 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 45085		Part Number	: D3121143	
Estimate Number	: 10279		Drawing Number	: D3121 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	22/01/2009	S.O. No. :	Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	11	Type :	MACHINED PARTS	Due Date	: 05/02/2009
Previous Run	: 43486		Qty:	8	Um: Each
Written By	:				
Checked & Approved By	: <u>JKD 09.01.22</u>				
Comment	: Est Rev:Pick:A 04.02.18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC Est Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M174B1250X02000	17-4 SS Bar 1.250 x 2.00			Q 10
Comment: Qty.: 0.3864 f(s)/Unit Total : 3.0912 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.250x02.000) Identify for D3121-113 Batch: <u>109850</u> <i>mmf 09/01/23</i>					
2.0	BAND SAW	BAND SAW			Q 10
Comment: BAND SAW Cut blanks: (1.250" x 2.000") 4.425" long <i>mmf 09/01/23</i>					
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1			PO
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3121-113 as per Folio FA330 and Dwg D3121 Identify as D3121-113 2-Deburr 3-Scribe batch number <i>1/J.F. 09/01/25</i> (8)					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-143 PAR #: N/A Fault Category: Prod Machined Part NCR: Yes No DQA: D Date: 09/02/03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/02/03

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/03	3.0	End mill came out of collet during machining, part came out of jig. Not enough materiel to hold it back on the jig.	J.F. 09/01/02	-2 parts scrap: no replace, cannot really hold part down any more.	J.F. 09/01/26	09/01/28	09/01/28	09/01/28
		R.c: Process / slight rad. on the corner of the material.						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 45085

Part Number: D3121143

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/01/25

(8)

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 09/01/29

6.0 D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3121-21	Bolt	<u>B43536</u>

Eb09/01/30

7.0 D3121241

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3121-241	Bearing Ass	<u>B43537</u>

Eb09/01/30

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-143 as per Dwg D3121.

Eb09/01/30

(8)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.01.30 (8)

(8)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 233

9/21/09

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 2:33:14 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 45085

Part Number: D3121143

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/03 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-0202

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: H5085
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121	Rev: E	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.080				
0.300	+/-0.010	.292				
R0.375	+/-0.010	R.375				
1.54	+/-0.030	1.54				
0.350	+/-0.010	.350				
R0.25	+/-0.030	R.25				
00.392	+0.002/-0.000	0.393				
00.201	+0.005/-0.000	.202				
2.540	+/-0.010	2.540				
1.590	+/-0.010	1.590				
0.160	+/-0.010	.160				
0.400	+/-0.010	.396				
1.220	+/-0.010	1.22				
1.600	+/-0.010	1.600				
3.80	+/-0.030	3.80				
1.800	+/-0.010	1.800				
R0.50	+/-0.030	R.50				
0.130	+/-0.010	.130				
3.41	+/-0.030	3.41				
3.65	+/-0.030	3.65				
2.24	+/-0.030	2.23				
45°	+/-0.1°	45°				
R0.25	+/-0.030	R.25				
3.97	+/-0.030	3.97				
R0.38	+/-0.030	R.38				
00.392	+0.002/-0.000	0.393				
00.201	+0.005/-0.000	.202				
0.268	+/-0.010	.266				
R0.260	+/-0.010	R.260				
0.080	+/-0.010	.080				
0.300	+/-0.010	.298				
0.381	+/-0.010	.381				
0.201	+/-0.010	.201				
0.580	+/-0.010	.583				

DART AEROSPACE LTD	Work Order:	45085
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121	Rev: E	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

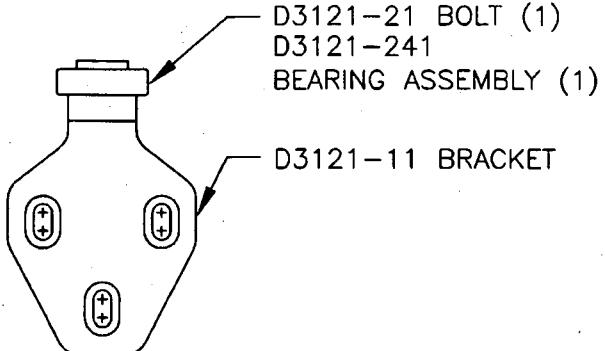
Measured by:	J.F.	Audited by:	J.L.	Prototype Approval:	N/A
Date:	09/01/24	Date:	09/01/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue P/O D3121-143	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	DD

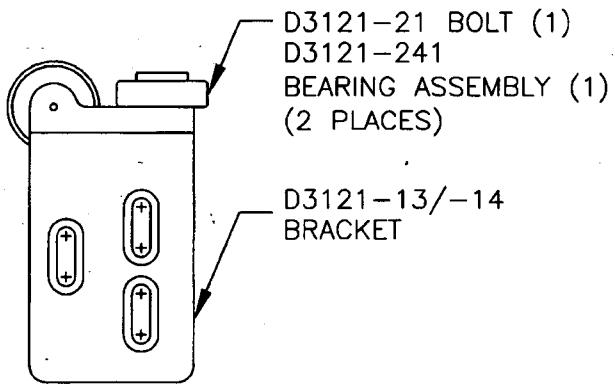
DART

DESIGN <i>A</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>TH</i>	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

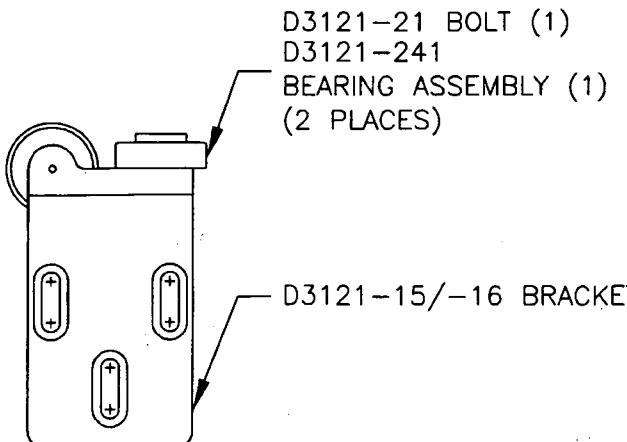
RELEASED
07.11.07 *WJD*



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

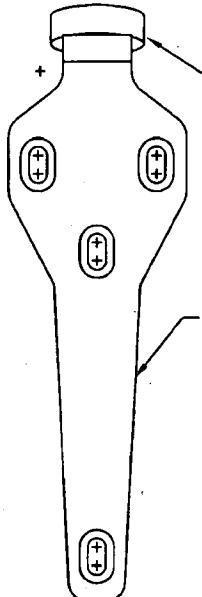
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

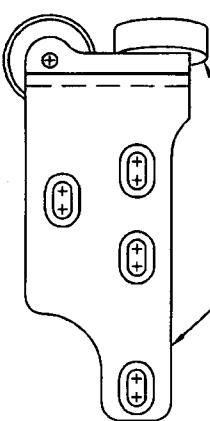
DART

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CHECKED <i>4</i>	APPROVED <i>4</i>	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

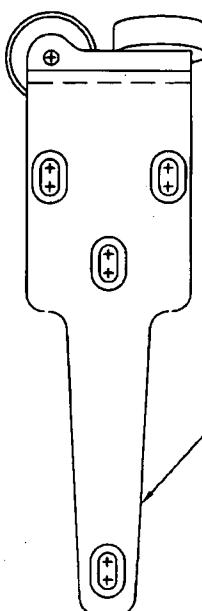


D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07 W



**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-03/-04)



**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-05/-06)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

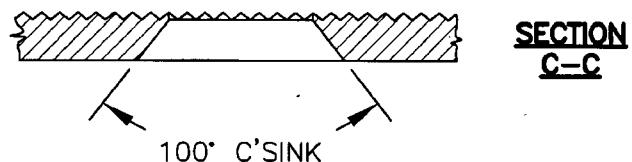
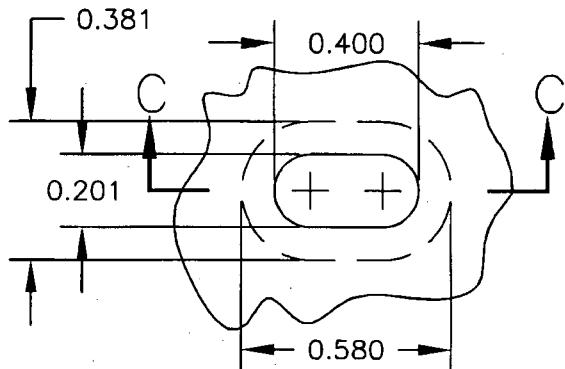
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

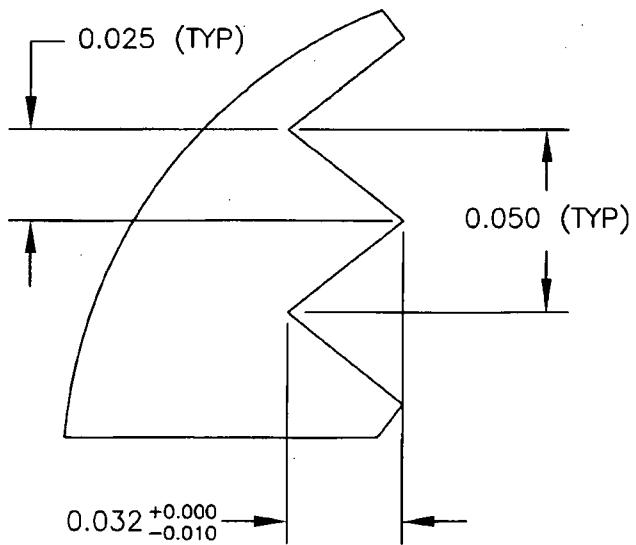
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		D3121	SHEET 3 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



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07.11.07 *W*

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

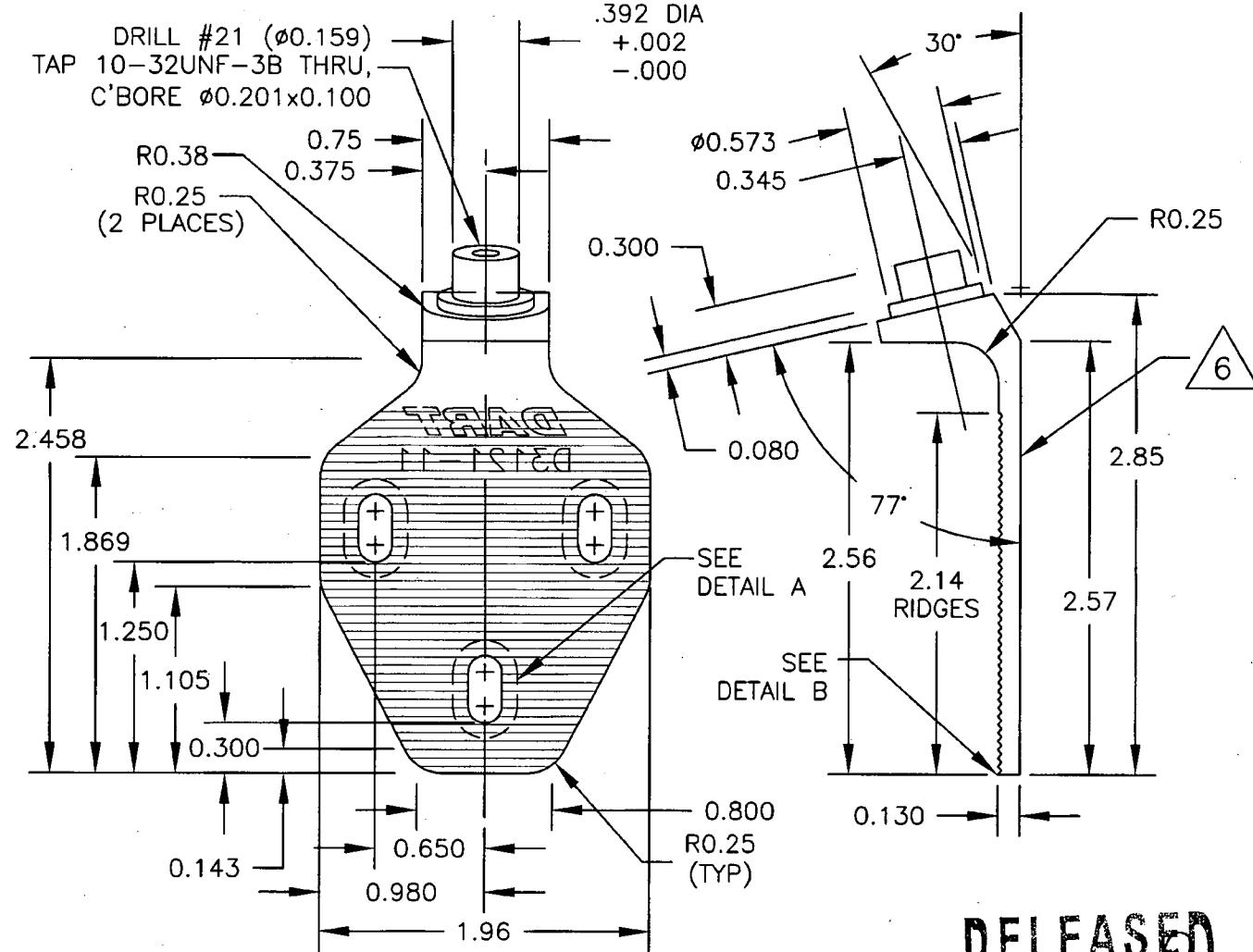
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED	APPROVED	DRAWING NO. D3121
DATE	TITLE	SCALE
07.11.07	BRACKET ASSEMBLY	1:1

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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WORK ORDER

NO. 45085

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

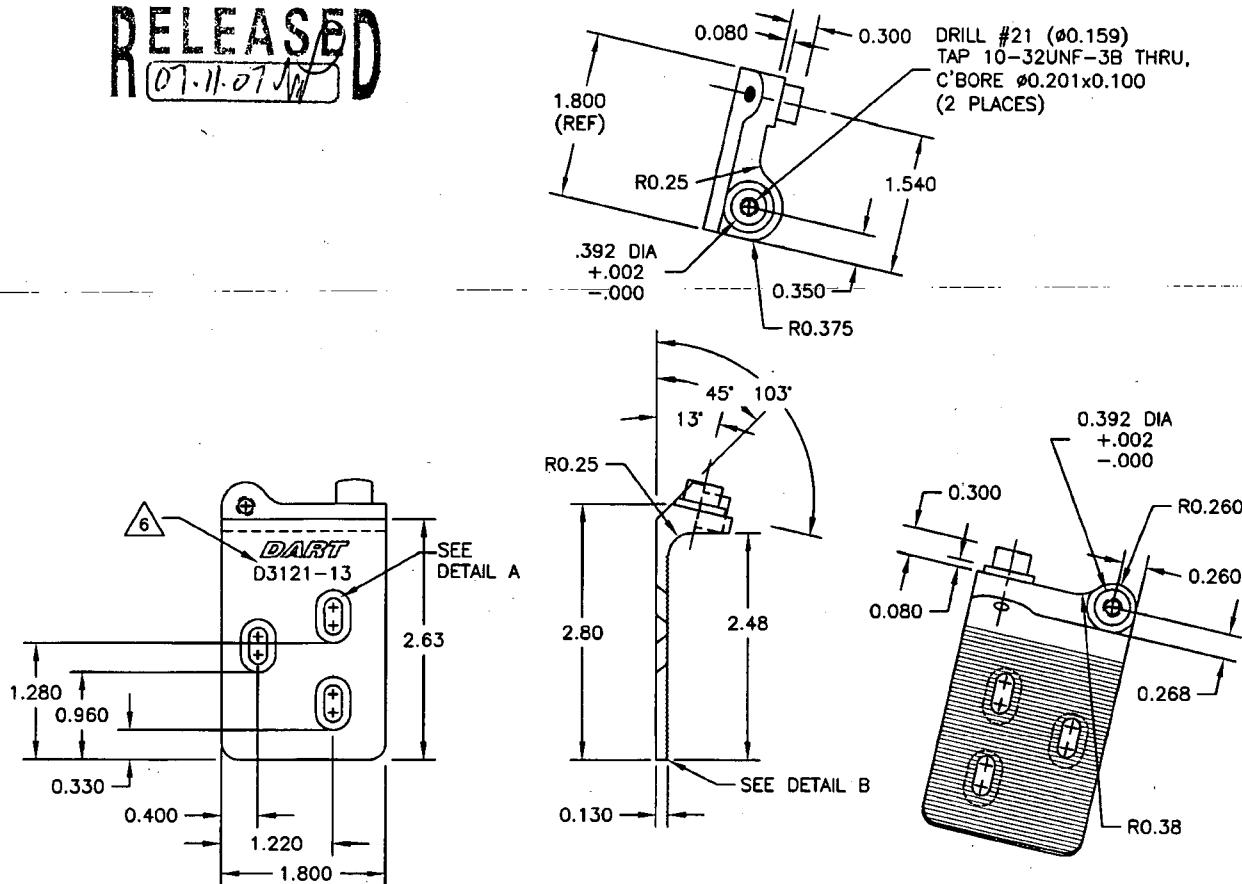
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D3121	SHEET 5 OF 10
DATE	TITLE	SCALE	
07.11.07	BRACKET ASSEMBLY	1:2	

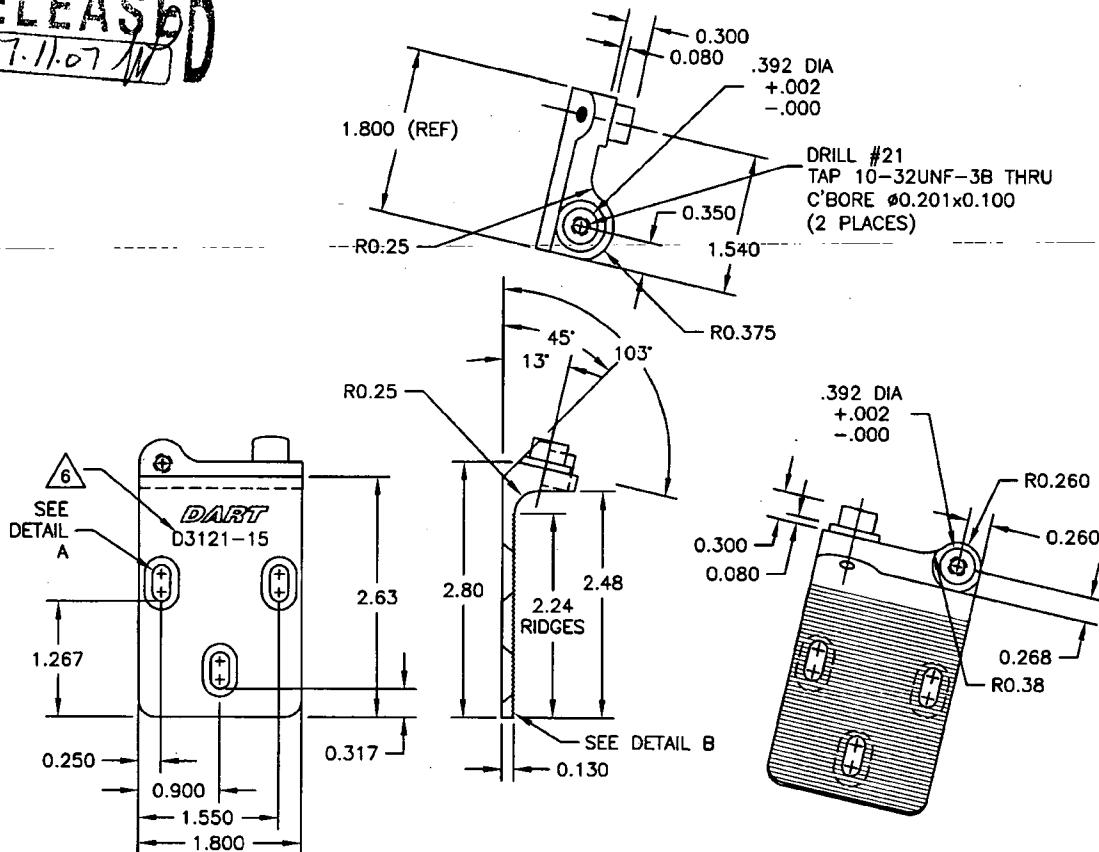
RELEASED
07.11.07**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) SHOP COPY
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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WORK ORDER
NO. 45085

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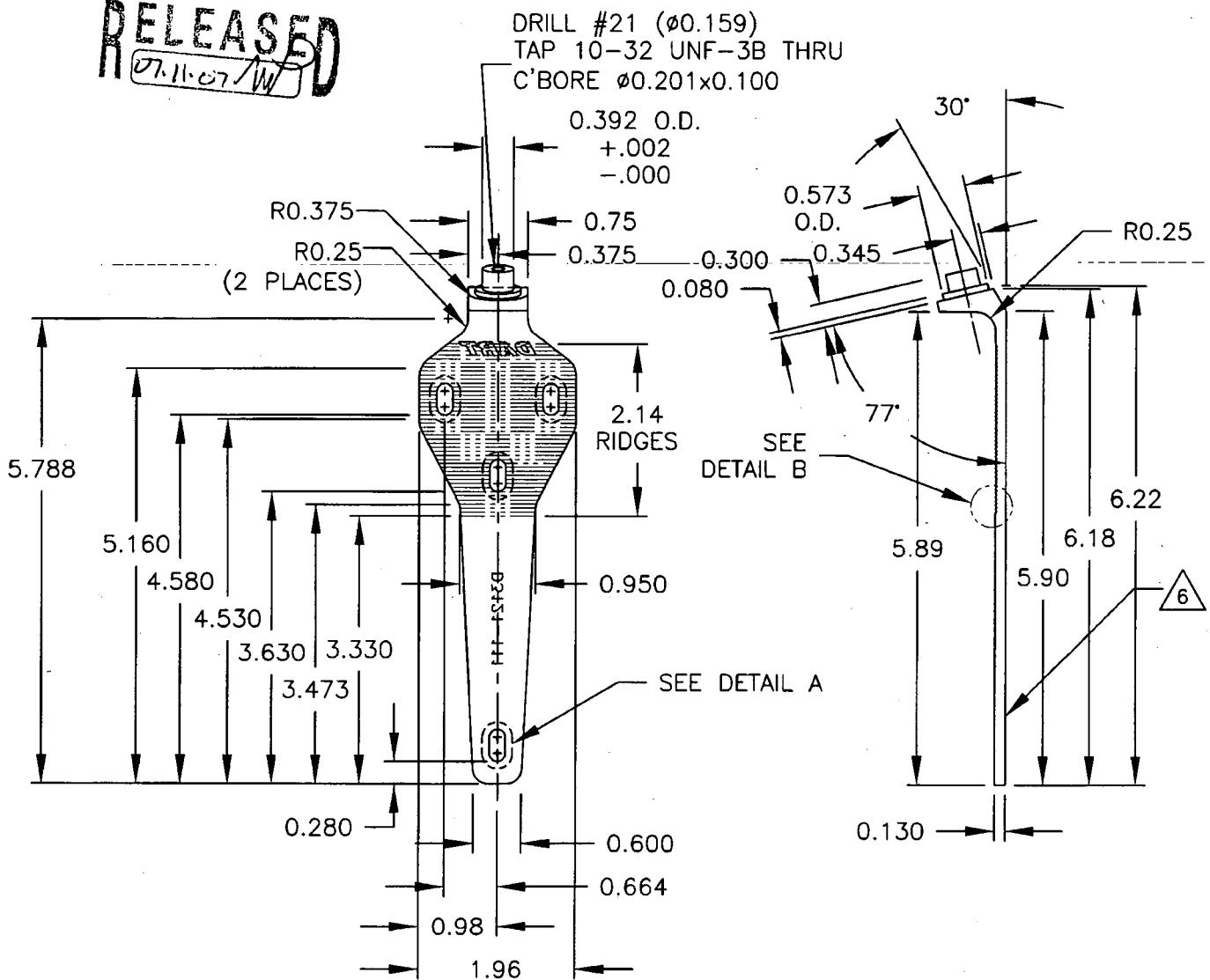
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CHECKED	APPROVED	DRAWING NO. D3121
DATE		REV. E SHEET 6 OF 10 TITLE SCALE 1:2

RELEASED
07.11.07**D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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07.11.07 / W



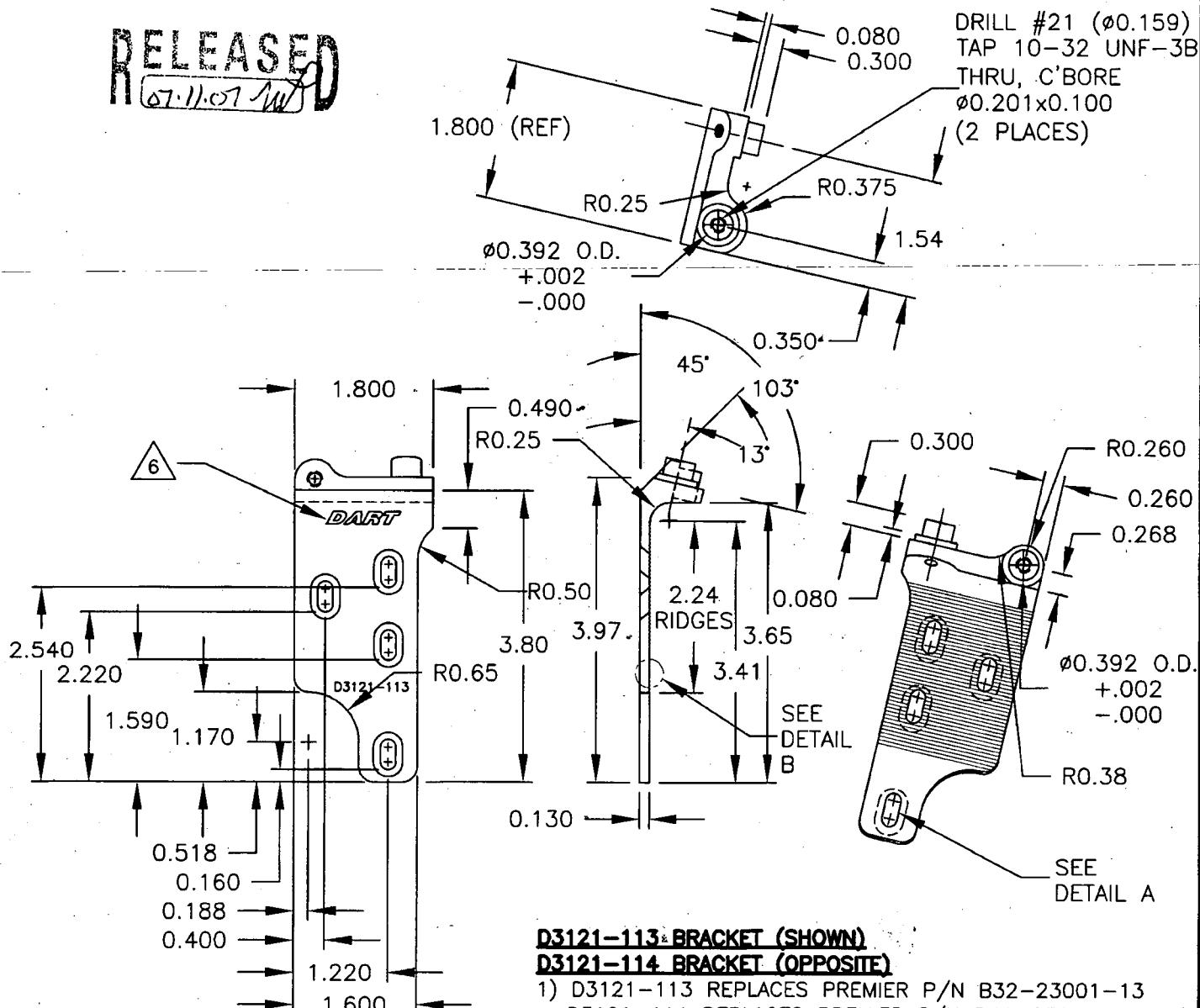
D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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NO. W5085

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CHECKED	APPROVED	DRAWING NO.	REV. E
DATE	07.11.07	D3121	SHEET 8 OF 10
		TITLE	SCALE
		BRACKET ASSEMBLY	1:2

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(07.11.07 WJ)

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WORK ORDER
NO. 45085

D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

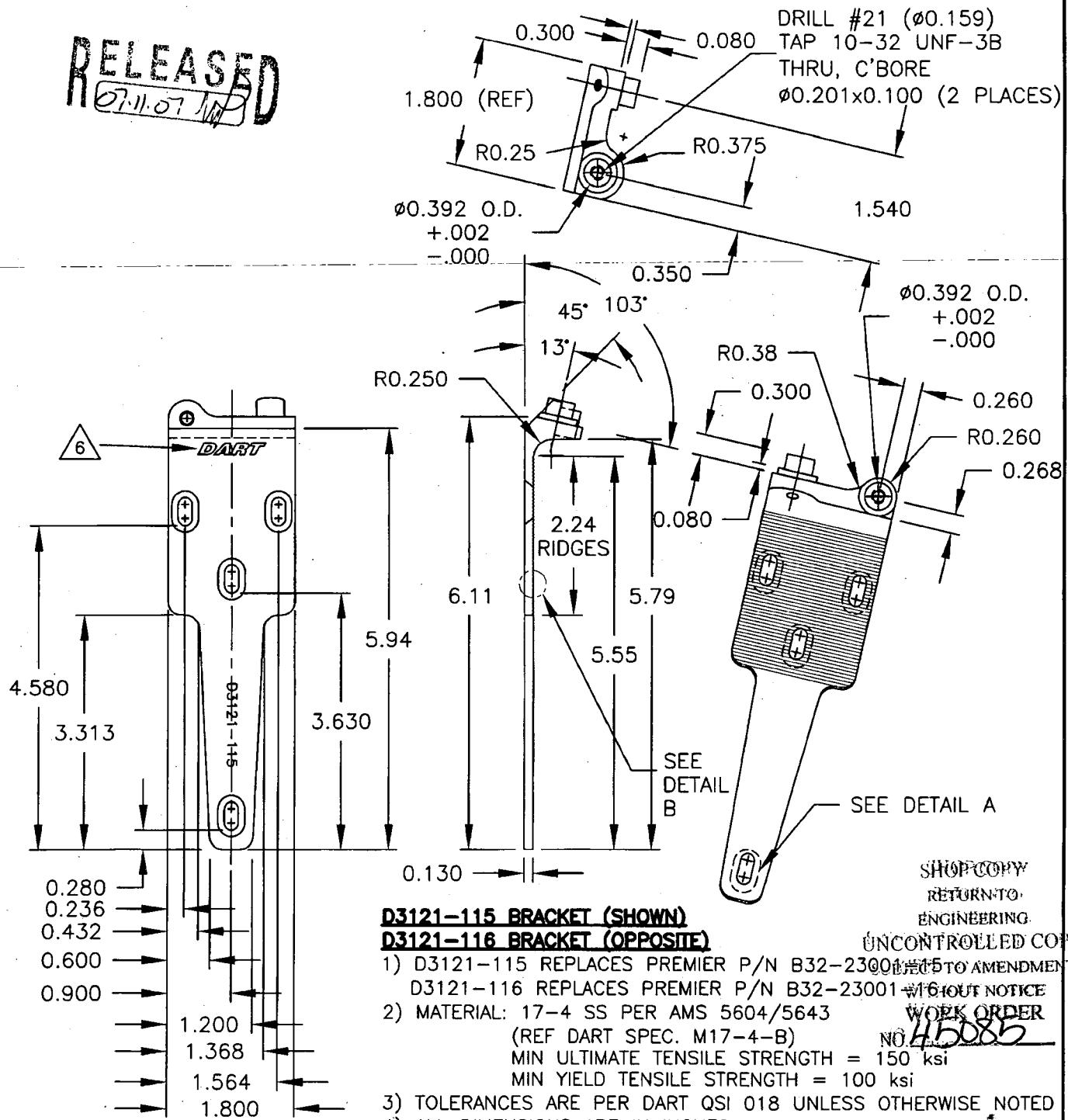
- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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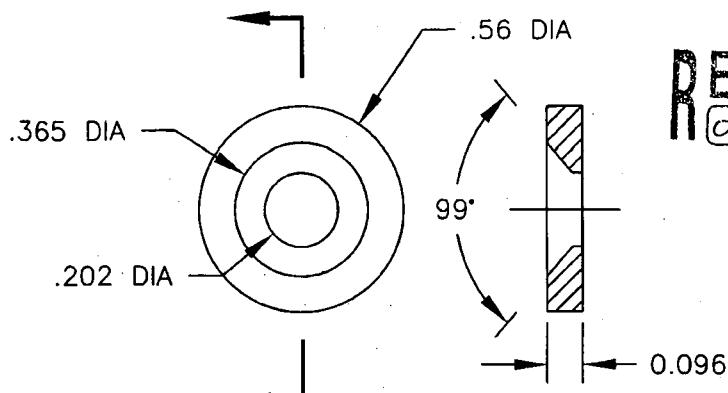
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D3121	SHEET 9 OF 10
DATE	TITLE	SCALE	1:2
07.11.07	BRACKET ASSEMBLY		

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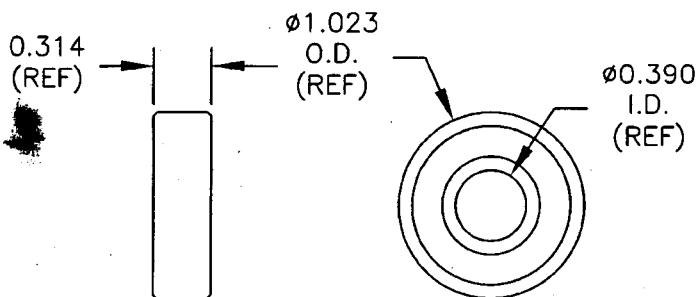
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D3121	SHEET 10 OF 10
DATE	TITLE	SCALE	
07.11.07	BRACKET ASSEMBLY	1:1	



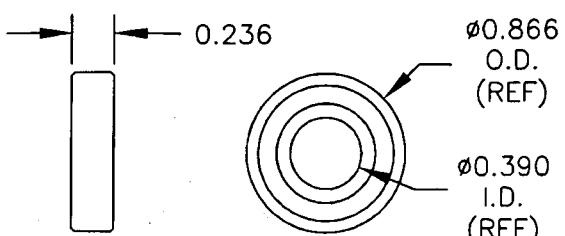
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



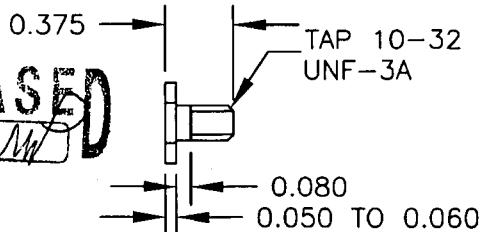
D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



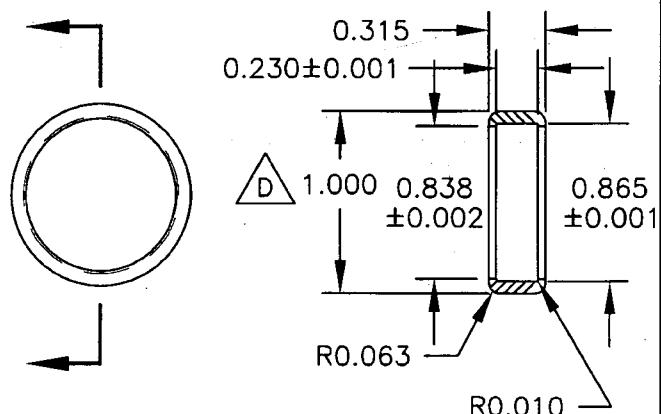
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-21 BOLT (SCALE 1:1)

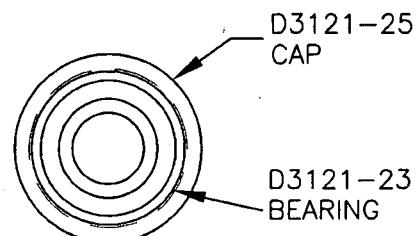
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15085



D3121-241 BEARING ASSEMBLY (SCALE 1:1)

